

Work Order ID 86620

86620

Page 1

Friday, July 06, 2012 10:12:53 AM

Item ID: D4522-17

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Linkage

Start Date: 7/5/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/19/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: *MF*

Date: *12-07-06* Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4522

B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: *B*

304 . 063

Prog Rev: *B*

2-Deburr as required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-7-10

B12-7-10

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

S.12/11/11

9 12-07-11

180

Identify as per dwg & Stock Location ST 115 0.00

180

Packaging

Memo

0.00

Packaging

9x

12-7-13

190

QC21- Final Inspection - Work Order Release 0.00

190

QC

Memo

0.00

Quality Control

ML5 12/07/13
ML5 12/07/13

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Friday, July 06, 2012 10:12:52 AM

Work Order ID: 86620
Parent Item: D4522-17
Parent Item Name: Linkage

Start Date: 7/5/2012 Required Date: 7/19/2012
Start Qty: 4.00 Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 12-01-04 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	157.4900	0.003	0.0126316			

304/316 Sheet .063

B12-7-10

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	157.49	
122245	157.49	

122245

(9)

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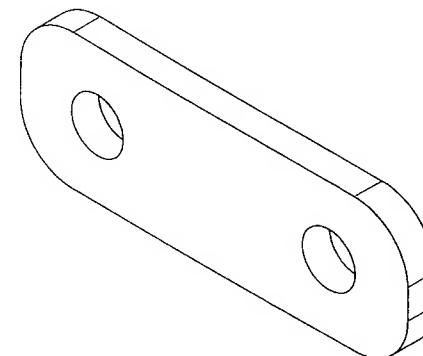
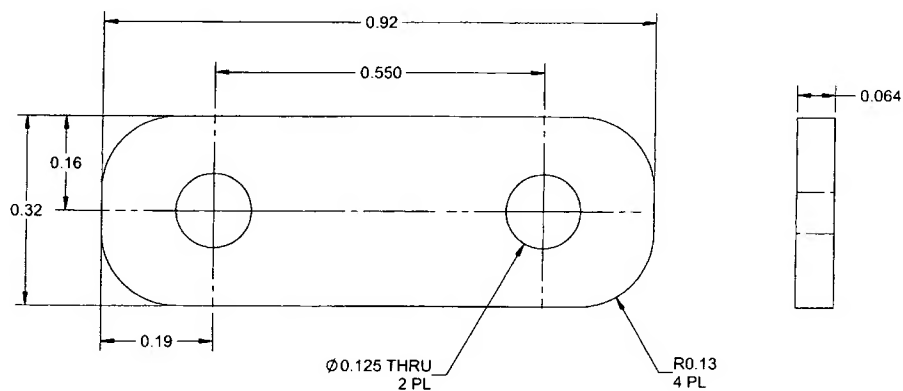
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D4522-17 LINKAGE

RELEASED
2012-06-13

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, ANNEALED, 2B FINISH
REF DART SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
- 7) WEIGHT: 0.01 lbs

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4522	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 17 OF 23	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOOR LATCH ASSY (412)	NTS
DATE	12.04.17	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	